



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D044-662-013
Job Sheet 180956



Part No: D044-662-013

Job Qty: 3 ea

Part Name: R44 Bearpaws - Large



DAS
21
9-89

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-01-30 JLM IPP Rev:B As per IIN 044-662 REV D 07-03-28 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		8/3/18	0.00	0.00	Start Up Stores/Pkg-1		AUG 14 2018
110	Packaging	3 pcs		8/3/18	0.00	0.00	Packaging1-1		AUG 14 2018
120	QC	3 pcs		8/3/18	0.00	0.00	QC4		38 7/10 18/08/14
125	DC	3 pcs		8/3/18	0.00	0.00	DC		21 18/08/14
130	Packaging	3 pcs		8/3/18	0.00	0.00	Packaging3-1		21 AUG 15 2018
140	QC21-FG	3 Ea		8/3/18	0.00	0.00	QC21		21 9-89

Part Op 125 - Photocopy bluefile & type labels per PPPD044-662-013 CHG 002

Descriptions: 130 - Identify and pack for shipping as per PPP D044-662-013

DAS
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9-89

AUG 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	8 12 Ea (4 ea)	90-Start up Operation	5067888
AN4-15A	Bolt	8 12 Ea (4 ea)	90-Start up Operation	5083012
D2529	Washer	16 24 Ea (8 ea)	90-Start up Operation	5035698
D3529-1	Bearpaw	4 6 Ea (2 ea)	90-Start up Operation	5005057x4
D3556-1	R44 Bearpaw Clamp	8 12 Ea (4 ea)	90-Start up Operation	5084583
D3601-1	Radius Block	16 24 Ea (8 ea)	90-Start up Operation	5077169
D4953-1	Cushion	8 12 Ea (4 ea)	90-Start up Operation	5084583
MS21042L4	Nut	16 24 Ea (8 ea)	90-Start up Operation	5084583
NAS1149D0463J	Washer	16 24 Ea (8 ea)	90-Start up Operation	5084583

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	12	378	0
	AN4-15A	12	453	0
	D2529	24	1,585	0
	D3529-1	6	6	0
	D3556-1	12	64	0
	D3601-1	24	124	0
	D4953-1	12	280	0
	MS21042L4	24	3,594	0
	NAS1149D0463J	24	11,622	0

Part Specifications

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____ / Supervisor Verification _____ Director _____ DART AEROSPACE 1270 Aberdeen Street Haverhill, MA 01830 Tel.: 1 617 832-8200 Email: sales@dartaero.com www.dartaerospace.com	
Root Cause				FAULT CATEGORY					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Los	
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Progr	
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock	
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :					
Misidentified	☐	Past Due	☐						

Specifications could not be found.

Plex 7/18/18 10:52 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.1 in 3.25 m	589 in-lb 6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb 2.81 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	129.1 in 3.28 m	800 in-lb 9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb 0.73 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.3 in 3.26 m	205 in-lb 2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)

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Revision: E

Date: 15.03.20

Change Record

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Part Number: D044-662-013Description: BEARPAW INSTALLATION[illegible]